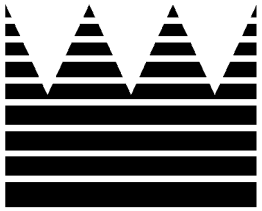

Models 380/381

Slush Freezers

Operating Instructions

047455-M

6/96

Complete this page for quick reference when service is required:

Taylor Distributor: _____

Address: _____

Phone: _____

Service: _____

Parts: _____

Date of Installation: _____

Information found on the data label:

Model Number: _____

Serial Number: _____

Electrical Specs: Voltage _____ Cycle _____

Phase _____

Maximum Fuse Size: _____ A

Minimum Wire Ampacity: _____ A

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047455–M

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Taylor Company
750 N. Blackhawk Blvd.
Rockton, IL 61072

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Note: Continuing research results in steady improvements; therefore, information in this manual is subject to change without notice.

Notes:

Section 1 To the Installer

This machine is designed for indoor use only.

DO NOT install the machine in an area where a water jet could be used. Failure to follow this instruction may result in serious electrical shock.

Assemble legs to the threaded holes on the underside of the unit. Slip rubber boots on leg flange to eliminate sliding.

Water Connections (Water Cooled Units Only)

An adequate cold water supply must be provided with a hand shut-off valve. On the rear of the unit, two 3/8" I.P.S. water connections for inlet and outlet have been provided for easy hook-up. 1/2" inside diameter water lines should be connected to the machine. (Flexible lines are recommended, if local codes permit.) Depending on local water conditions, it may be advisable to install a water strainer to prevent foreign substances from clogging the automatic water valve. There will be only one water "in" and one water "out" connection. DO NOT install a hand shut-off valve on the water "out" line! Water should always flow in this order: first, through the automatic water valve; second, through the condenser; and third, through the outlet fitting to an **open trap drain.**

Air Cooled Units

Air cooled units require a minimum of 6" (152 mm) of clearance around **all** sides of the freezer to allow for adequate air flow across the condenser. Failure to allow adequate clearance can reduce the refrigeration capacity of the freezer and possibly cause permanent damage to the compressor.

Electrical Hook-up Installation For 60 Cycle, 1 Ph, Supplied With Cord and Plug

CAUTION: THIS EQUIPMENT MUST BE PROPERLY GROUNDED. FAILURE TO DO SO CAN RESULT IN SEVERE PERSONAL INJURY FROM ELECTRICAL SHOCK.

This equipment is supplied with a 3 wire cord and grounding type plug for connection to a single phase, 60 cycle, branch circuit supply. This unit must be plugged into a properly grounded receptacle. The cord and plug provided for is 20A; therefore the wall outlet must also be 20A. Check the data label, located on the rear panel, for electrical specifications.

In the United States, this equipment is intended to be installed in accordance with the National Electrical Code (NEC), ANSI/NFPA 70-1987. The purpose of the NEC code is the practical safeguarding of persons and property from hazards arising from the use of electricity. This code contains provisions considered necessary for safety. Compliance therewith and proper maintenance will result in an installation essentially free from hazard!

In all other areas of the world, equipment should be installed in accordance with the existing local codes. Please contact your local authorities.

Stationary appliances which are not equipped with a power cord and a plug or other device to disconnect the appliance from the power source must have an all-pole disconnecting device with a contact gap of at least 3 mm installed in the external installation.

Beater rotation must be **counterclockwise** as viewed looking into the freezing cylinder.

Permanent wiring may be employed if required by local codes. Instructions for conversion to permanent wiring are as follows:

1. Be sure the freezer is electrically disconnected.
2. Remove the left side and rear panels and locate the small electrical box.
3. Remove the factory-installed cord and strain relief bushing.
4. Route incoming permanent wiring through the 7/8" (22 mm) hole in the lower rear of the freezer.
5. Connect the two power supply leads. Attach the ground (earth) wire to the grounding lug inside the electrical box.
6. Be the sure unit is properly grounded before applying power.

FOLLOW YOUR LOCAL ELECTRICAL CODES!

Section 2 To the Operator

The freezer you have purchased has been carefully engineered and manufactured to give you dependable operation. The Taylor Model 380/381, when properly operated and cared for, will produce a consistent quality product. Like all mechanical products, this machine will require cleaning and maintenance. A minimum amount of care and attention is necessary if the operating procedures outlined in this manual are followed closely.

This Operator's Manual should be read before operating or performing any maintenance on your equipment.

Your Model 380/381 will NOT eventually compensate and correct for any errors during the set-up or filling operations. Thus, the initial assembly and priming procedures are of extreme importance. It is strongly recommended that all personnel responsible for the equipment's operation study these procedures in order to be properly trained and to make sure that no misunderstandings exist.

In the event you should require technical assistance, please contact your local authorized Taylor Distributor.

If the crossed out wheeled bin symbol is affixed to this product, it signifies that this product is compliant with the EU Directive as well as other similar legislation in effect after August 13, 2005. Therefore, it must be collected separately after its use is completed, and cannot be disposed as unsorted municipal waste.

The user is responsible for returning the product to the appropriate collection facility, as specified by your local code.

For additional information regarding applicable local laws, please contact the municipal facility and/or local distributor.

Compressor Warranty Disclaimer

The refrigeration compressor(s) on this machine are warranted for the term indicated on the warranty card accompanying this machine. However, due to the Montreal Protocol and the U.S. Clean Air Act Amendments of 1990, many new refrigerants are being tested and developed, thus seeking their way into the service industry. Some of these new refrigerants are being advertised as drop-in replacements for numerous applications. It should be noted that, in the event of ordinary service to this machine's refrigeration system, **only the refrigerant specified on the affixed data label should be used**. The unauthorized use of alternate refrigerants will void your compressor warranty. It will be the owner's responsibility to make this fact known to any technician he employs.

It should also be noted that Taylor does not warrant the refrigerant used in its equipment. For example, if the refrigerant is lost during the course of ordinary service to this machine, Taylor has no obligation to either supply or provide its replacement either at billable or unbillable terms. Taylor does have the obligation to recommend a suitable replacement if the original refrigerant is banned, obsoleted, or no longer available during the five year warranty of the compressor.

The Taylor Company will continue to monitor the industry and test new alternates as they are being developed. Should a new alternate prove, through our testing, that it would be accepted as a drop-in replacement, then the above disclaimer would become null and void. To find out the current status of an alternate refrigerant as it relates to your compressor warranty, call the local Taylor Distributor or the Taylor Factory. Be prepared to provide the Model/Serial Number of the unit in question.

Section 3 Safety

We at Taylor Company are concerned about the safety of the operator when he or she comes in contact with the freezer and its parts. Taylor has gone to extreme efforts to design and manufacture built-in safety features to protect both you and the service technician. As an example, warning labels have been attached to the freezer to further point out safety precautions to the operator.

IMPORTANT – Failure to adhere to the following safety precautions may result in severe personal injury. Failure to comply with these warnings may damage the machine and its components. Component damage will result in part replacement expense and service repair expense.

To Operate Safely:

DO NOT operate the freezer without reading this operator's manual. Failure to follow this instruction may result in equipment damage, poor freezer performance, health hazards, or personal injury.

- **DO NOT** operate the freezer unless it is properly grounded.
- **DO NOT** attempt any repairs unless the main power supply to the freezer has been disconnected.
- **DO NOT** operate the freezer with larger fuses than specified on the freezer data label.

Failure to follow these instructions may result in electrocution or damage to the machine. Contact your local authorized Taylor Distributor for service.

DO NOT use a water jet to clean or rinse the freezer. Failure to follow this instruction may result in serious electrical shock.

- **DO NOT** allow untrained personnel to operate this machine.
- **DO NOT** operate the freezer unless all service panels and access doors are restrained with screws.
- **DO NOT** remove the door, beater, scraper blades, or drive shaft unless the power switch is in the "OFF" position.
- **DO NOT** put objects or fingers in the door spout.

Failure to follow these instructions may result in contaminated product or severe personal injury to fingers or hands from hazardous moving parts.

USE EXTREME CAUTION when removing the beater assembly. The scraper blades are very sharp and may cause injury.

These freezers must be placed on a level surface. Failure to comply may result in personal injury or equipment damage.

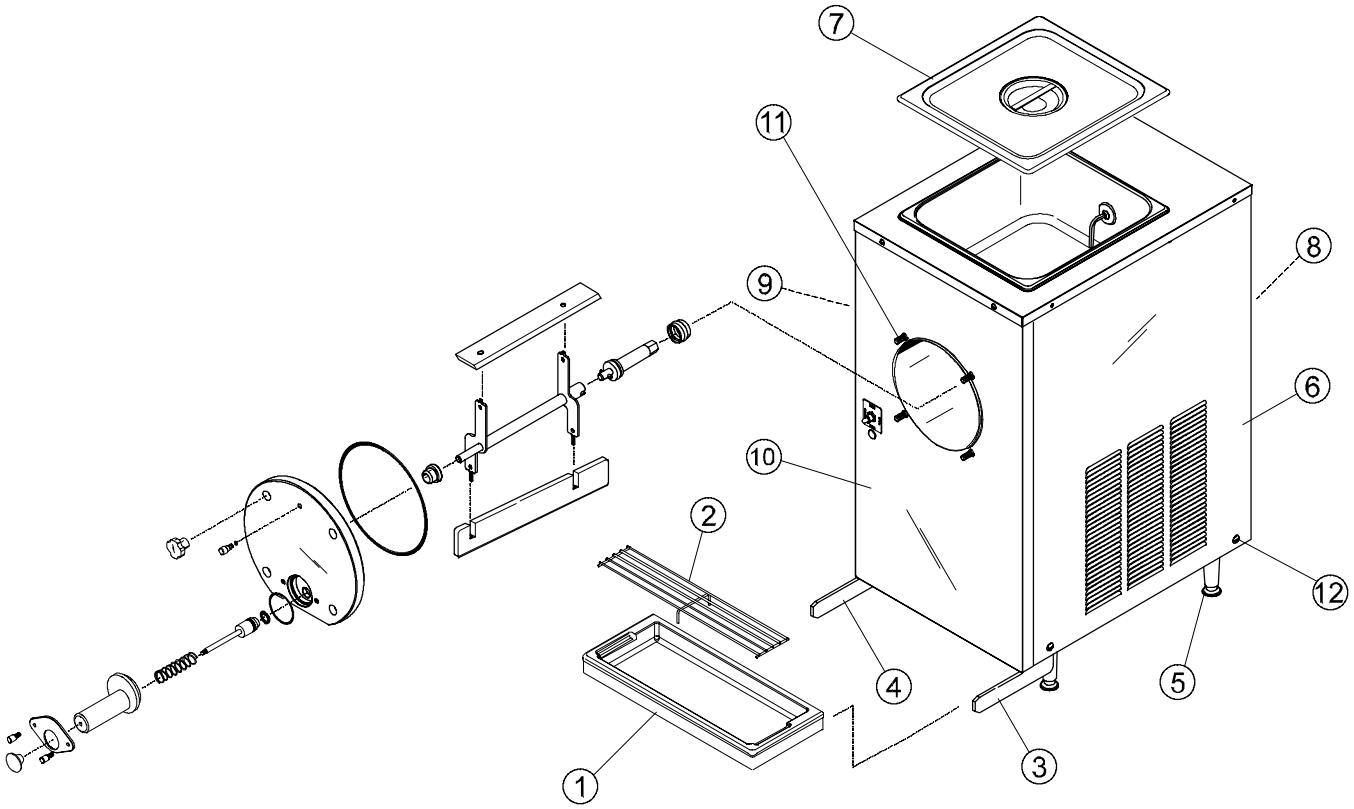
DO NOT obstruct air intake and discharge openings: 6" (152 mm) minimum air space on front, sides and rear of the unit. Failure to follow this instruction may cause poor freezer performance and damage to the machine.

These freezers are designed to operate indoors, under normal ambient temperatures of 70°–75°F (21°–24°C). The freezers have successfully performed in high ambient temperatures of 104°F (40°C) at reduced capacities.

NOISE LEVEL: Airborne noise emission does not exceed 78 dB(A) when measured at a distance of 1.0 meter from the surface of the machine and at a height of 1.6 meters from the floor.

Section 4 Operator Parts Identification

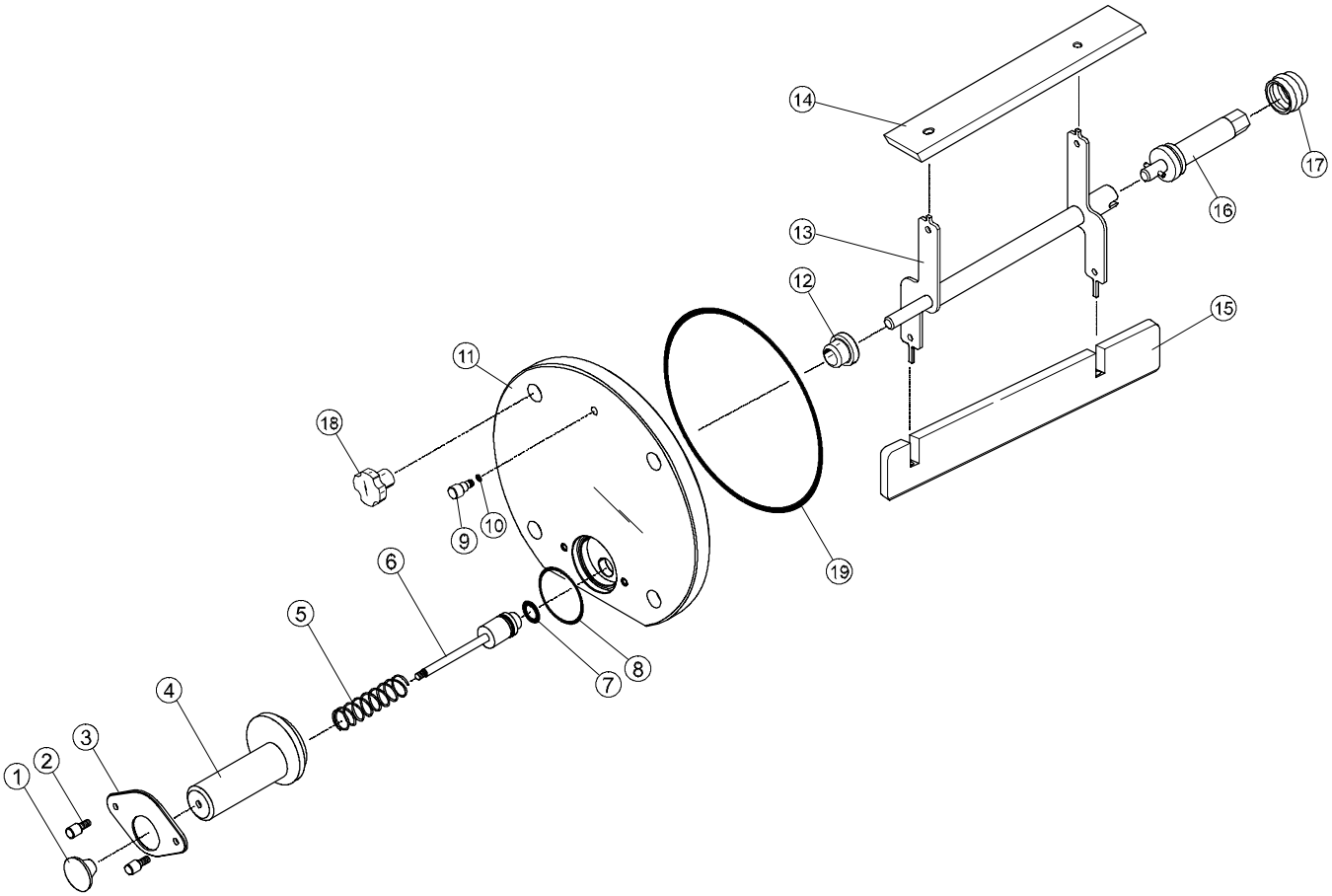
Models 380/381



Item	Description	Part No.
1	Drip Tray Assembly	X46848
2	Splash Shield	046851
3	Bracket-Drip Tray - Right	046846
4	Bracket-Drip Tray - Left	046847
5	Leg - 4” Stud - Plastic	024755
6	Panel-Side - Right (380)	047537
6a	Panel-Side - Right (381)	046843

Item	Description	Part No.
7	Hopper Cover - 12 Qt.	045416
8	Panel-Rear	046813
9	Panel-Side - Left	046844
10	Panel-Front	046845
11	Stud	023057
12	Screw 10-24 x 1/2 HD	049189

Models 380/381 Beater Assembly



Item	Description	Part No.
1	Knob-Draw Valve	047358
2	Screw-Thumb 1/4-20	047632
3	Plate-Draw Spout Mounting	047355
4	Spout-Door	047354
5	Spring-Comp.	047357
6	Valve-Draw	047353
7	O-Ring .943 OD x .731 ID	047356
8	O-Ring 2-3/8 OD x 1/16 Wall	046830
9	Plug-Prime	046833
10	O-Ring 9/32 OD x 1/16 Wall	029751

Item	Description	Part No.
11	Door Assembly	X47648
12	Bearing-Front	046834
13	Beater Assembly	X50525
14	Blade-Scraper	046840
15	Baffle-Beater	046839
16	Shaft A.-Drive	X50521
17	Seal-Drive Shaft	032560
18	Nut-Stud	045644
19	O-Ring - Freezer Door	027814

Section 5 Important: To the Operator

Control Switch

The center position is “OFF”. The “WASH” position activates the beater motor only. The “AUTO” position allows the beater motor and the compressor to run.

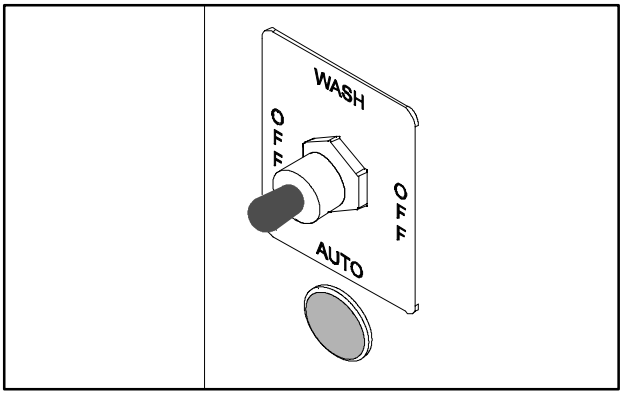


Figure 1

Torque Adjustment Lever

The viscosity (thickness) of the product is controlled by a sensing device called the torque adjustment lever. The torque adjustment lever is located on the rear of the unit. To adjust the viscosity of the product, remove the plate. To achieve a thicker product, move the lever to the left. To achieve a thinner product, move the lever to the right. Replace the plate.

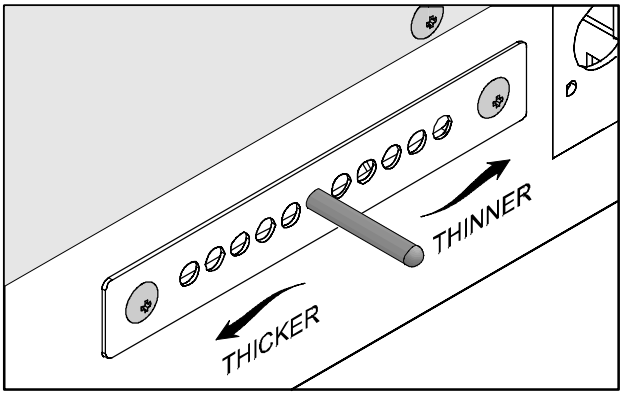


Figure 2

Indicator Light - “Mix Low”

A mix level indicating light is located on the front of the machine. When the light is flashing, it indicates that the mix hopper has a low supply of product. The hopper should be filled as soon as possible. Neglecting to add mix when the light comes on will cause the machine to sway and may cause damage to the beater assembly and freezer door.

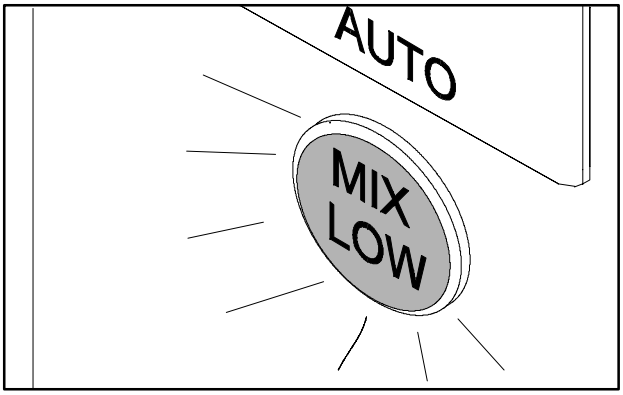


Figure 3

Section 6 Operating Procedures

The Model 380/381 has a 14 quart (13.2 liter) mix hopper and the freezing cylinder holds 10 quarts (9.5 liters) of product.

We begin our instructions at the point where the parts are disassembled and laid out to dry.

The following procedures will explain how to assemble the parts into the freezer, sanitize them, and prime the freezer with fresh product.

If you are disassembling the machine for the first time or need information to get to this starting point in our instructions, turn to “Disassembly” on page 12, and start there.

Assembly

MAKE SURE THE CONTROL SWITCH IS IN THE “OFF” POSITION.

Note: When lubricating parts, use an approved food grade lubricant (example: Taylor Lube).

Step 1
Lubricate the groove and the shaft portion of the drive shaft. Slide the seal over the shaft and groove until it fits into place. **DO NOT** lubricate the hex end of the drive shaft. Fill the inside portion of the seal with 1/4” more lubricant. Lubricate the flat side of the seal that fits onto the rear shell bearing.

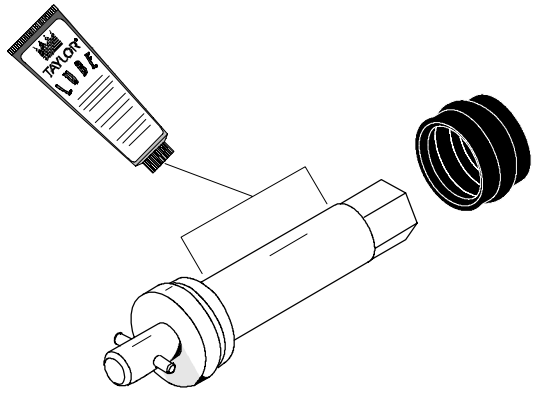


Figure 4

Insert the drive shaft into the freezing cylinder (hex end first) and into the rear shell bearing. The seal must fit securely over the rear shell bearing. Engage the hex end firmly into the drive coupling. The drive shaft must fit into the drive coupling without binding.

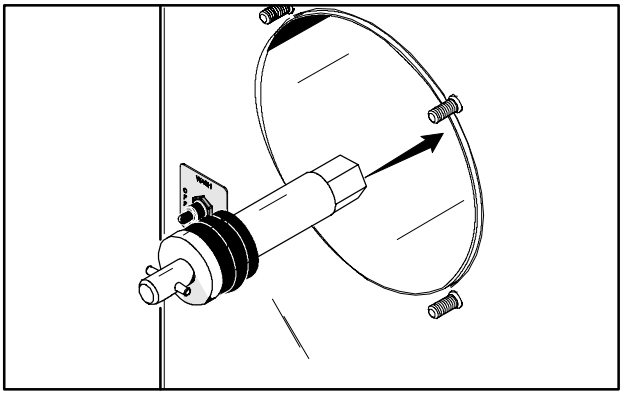


Figure 5

Step 2
Install the beater assembly. First check the scraper blade for any nicks or signs of wear. Replace the blade if it is nicked or worn.

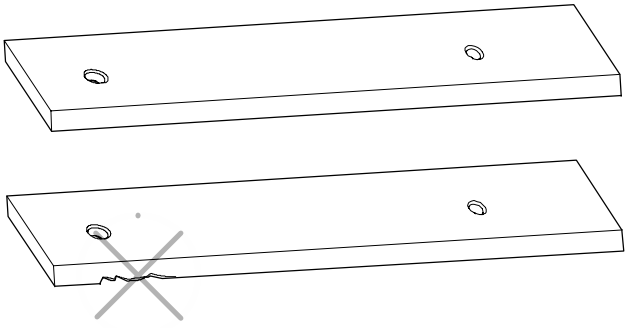


Figure 6

Place the scraper blade and baffle blade on their respective holding pins.

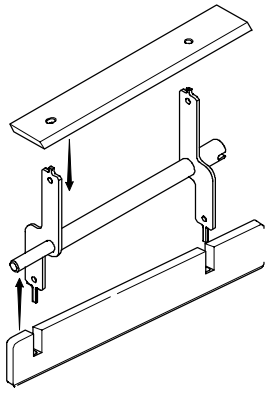


Figure 7

With the scraper blade in the 6 o'clock position, slide the beater into the freezing cylinder about one-third of the way. Looking into the freezing cylinder, align the slots on the beater assembly with the pins on the drive shaft. Slide the beater to the rear of the freezing cylinder and over the end of the drive shaft. When in position, the beater assembly will not protrude beyond the front of the freezing cylinder.

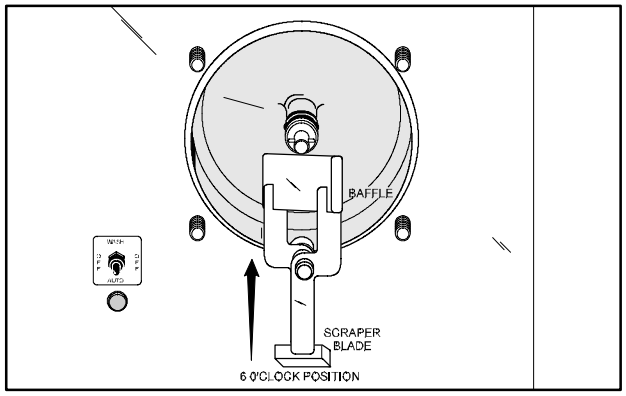


Figure 8

Step 3
Install the draw valve.

Install the door port o-ring and draw valve o-ring. Lubricate the draw valve and the inside of the door.

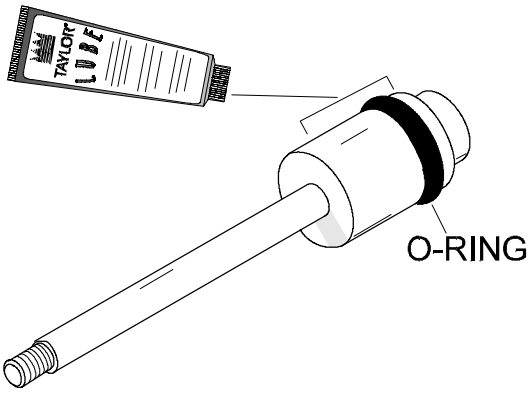


Figure 9

Insert the draw valve spring into the door spout. Insert the draw valve into the door spout from the rear. Push the draw valve through the spring, until the threaded end emerges from the front of the door spout. Screw the draw valve knob onto the draw valve assembly.

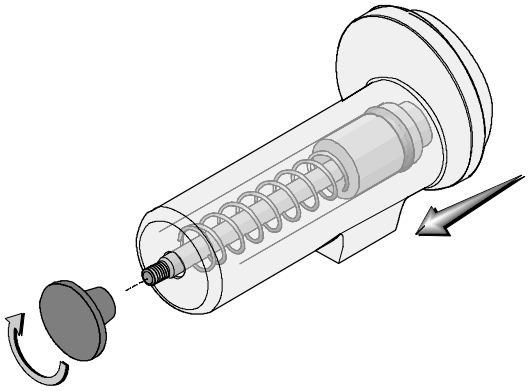


Figure 10

Install the draw valve assembly onto the door. Press the door spout plate over the door spout, and align it with the threads in the door. Insert the thumb screws in the holes on the door spout plate. Tighten the screws until the plate is secure.

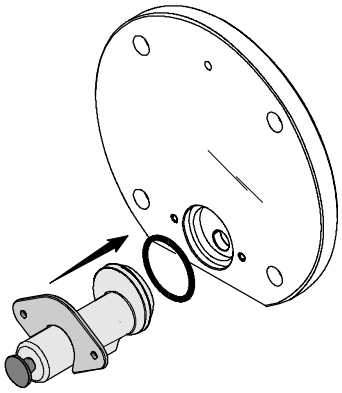


Figure 11

Step 4
Slide the o-ring into the groove on the prime plug. Apply an even coat of lubricant to the o-ring and shaft.

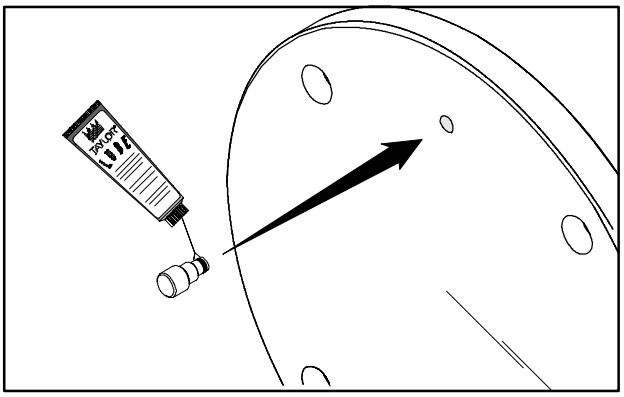


Figure 12

Install the prime plug into the bleed port in the top of the freezer door. Do not over-tighten the prime plug.

Step 5
Place the large o-ring into the door groove and lightly lubricate the parts.

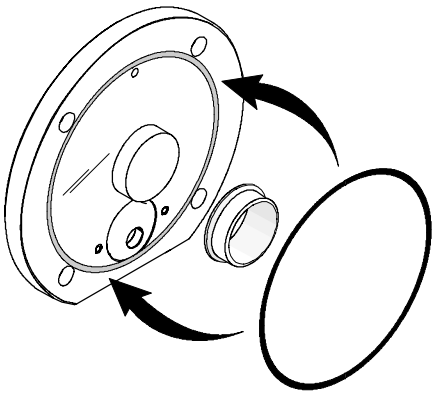


Figure 13

Note: Discard o-rings and install new o-rings every three months.

Step 6
Install the front bearing. **DO NOT** lubricate the front bearing.

Step 7
Install the freezer door. Position the door on the four studs on the front of the freezing cylinder. Firmly push the door into place.

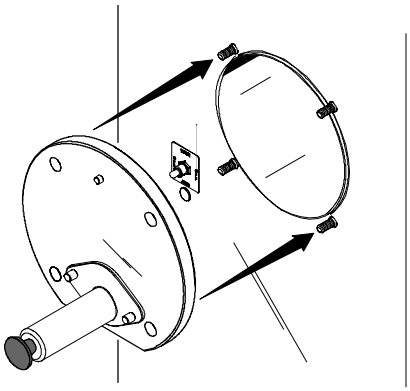


Figure 14

Install the four handscrews on the studs. Finger-tighten the screws equally in a criss-cross pattern to insure that the door is snug. **Do not over-tighten the handscrews.**

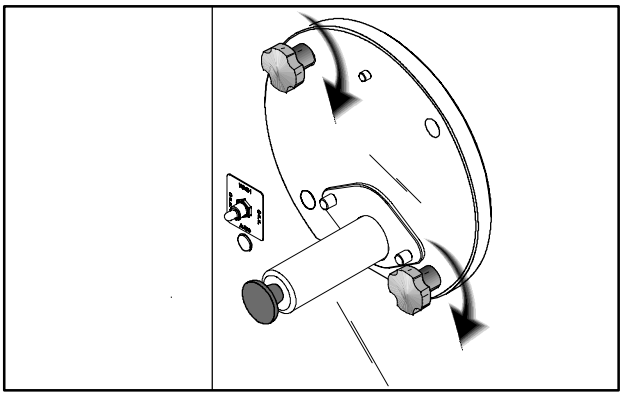


Figure 15

Step 8
Install the front drip tray and the splash shield under the door spout.

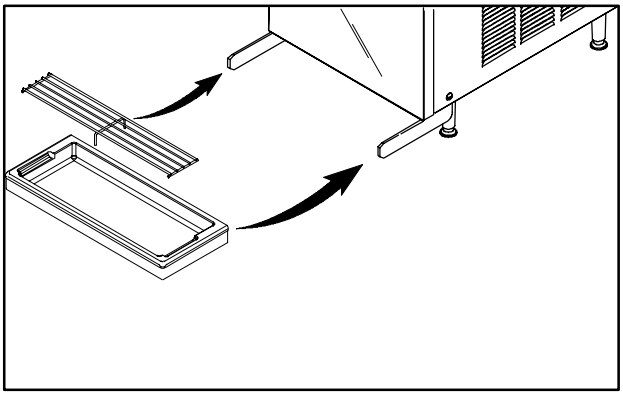


Figure 16

Sanitizing

Step 1
Prepare two gallons (7.6 liters) of an approved 100 PPM sanitizing solution (example: Kay-5). Use WARM WATER AND FOLLOW THE MANUFACTURER'S SPECIFICATIONS.

Step 2
Pour the two gallons (7.6 liters) of sanitizing solution into the hopper and allow it to flow into the freezing cylinder.

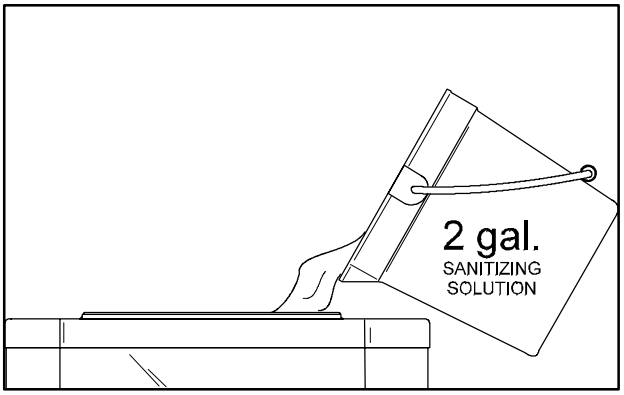


Figure 17

Step 3
While the solution is flowing into the freezing cylinder, brush clean the mix hopper, mix inlet hole, and mix level sensing probe.

Step 4
Remove the prime plug and allow all of the solution to flow into the freezing cylinder. Replace the prime plug.

Step 5
Place the control switch in the "WASH" position. This will cause the sanitizing solution in the freezing cylinder to be agitated. Allow the solution to agitate for five minutes.

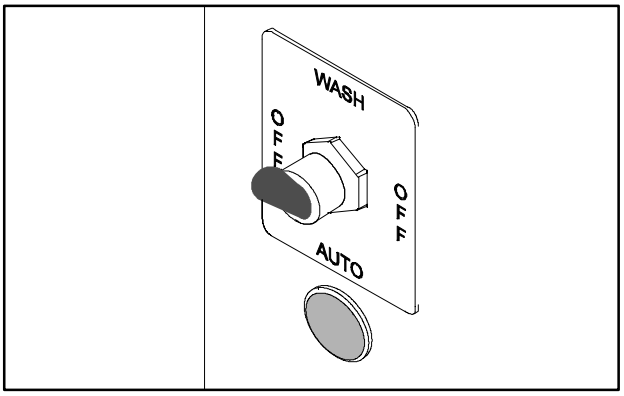


Figure 18

Step 6
Place the control switch in the "OFF" position. Place an empty mix pail beneath the door spout. Open the draw valve and draw off all of the sanitizing solution. When the sanitizer stops flowing from the door spout, close the draw valve.

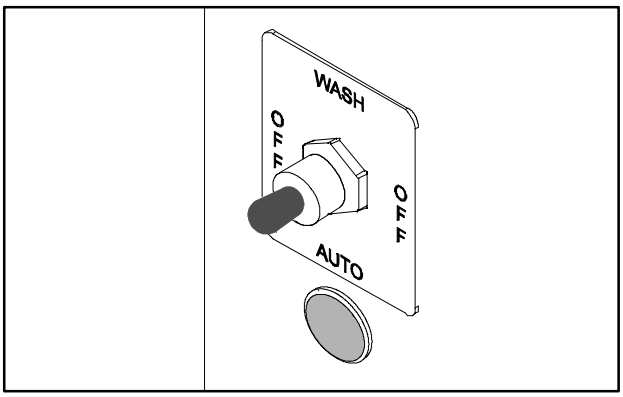


Figure 19

Priming

Step 1
Remove the prime plug from the bleed port. With a mix pail beneath the door spout, open the draw valve. Fill the hopper with FRESH product and allow it to flow into the freezing cylinder. This will force out any remaining sanitizing solution. When full strength product is flowing from the door spout, close the draw valve.

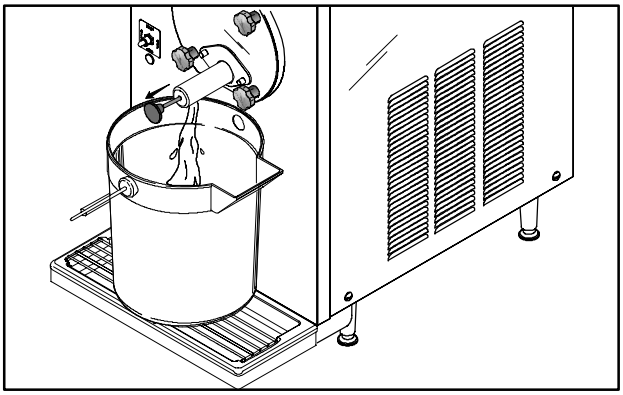


Figure 20

Step 2
When product rises to the bleed port, replace the prime plug.

Step 3
Place the hopper cover in position.

Step 4
Place the control switch in the “AUTO” position. When the unit cycles off, the product will be at serving viscosity.

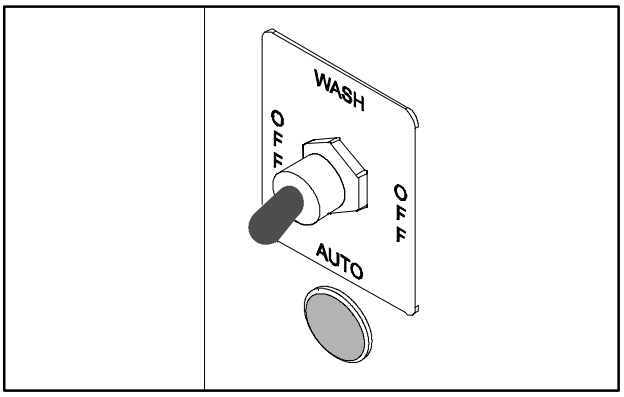


Figure 21

Closing Procedure

To disassemble the Model 380/381, the following items will be needed:

- Two cleaning pails
- Sanitized stainless steel rerun can with lid
- Necessary brushes provided with freezer
- Cleaner
- Single service towels

Draining Product From The Freezing Cylinder

Step 1
To allow frozen product to soften for draining, place the control switch in the “WASH” position as far ahead of the cleaning time as possible.

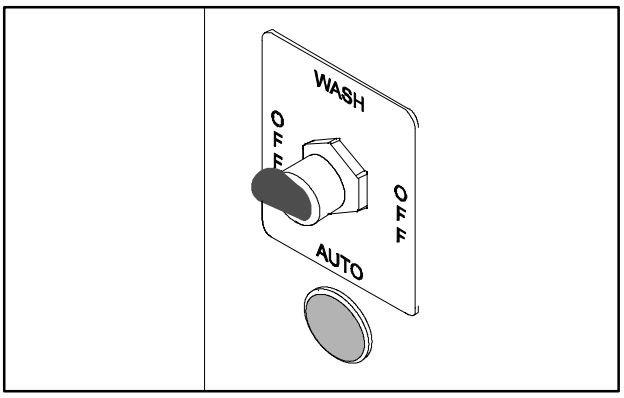


Figure 22

Step 2
Remove the hopper cover and take it to the sink for cleaning.

Step 3
With a pail beneath the door spout, open the draw valve.

Note: Once the freezing cylinder is 1/2 empty, place the control switch in the “OFF” position. This will promote easier product drawing.

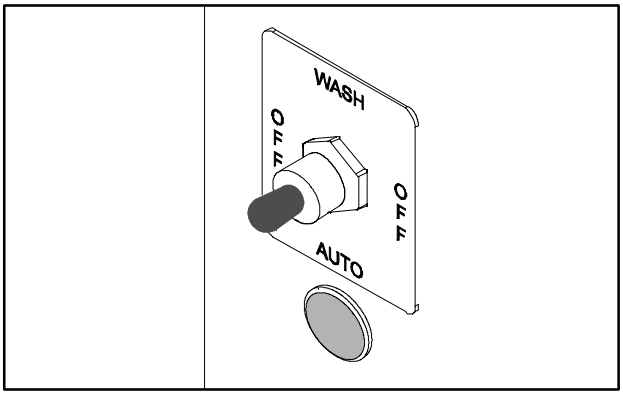


Figure 23

Step 4
When all of the product has been drained from the mix hopper and the freezing cylinder, close the draw valve. Make sure the control switch is in the “OFF” position. If local health codes permit, empty the rerun into the rerun can. Cover the container and place it in the walk-in cooler.

FOLLOW YOUR LOCAL HEALTH CODES.

Rinsing

Step 1
Pour two gallons (7.6 liters) of cool, clean water into the mix hopper. With the brushes provided, scrub the mix hopper, the mix inlet hole, and the mix level sensing probe.

Step 2
Remove the prime plug and allow all of the water to flow into the freezing cylinder. Replace the prime plug.

Step 3
Place the control switch in the “WASH” position. With a mix pail beneath the door spout, open the draw valve. Drain all the rinse water from the freezing cylinder. When the rinse water stops flowing from the door spout, close the draw valve and place the control switch in the “OFF” position.

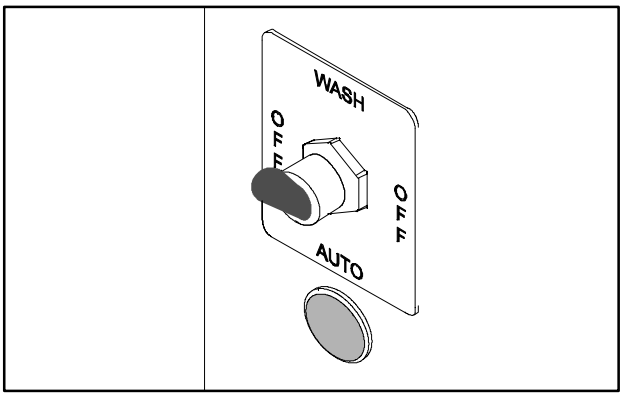


Figure 24

Repeat this procedure until the rinse water being drawn from the freezing cylinder is clear.

Cleaning

Step 1
Prepare two gallons (7.6 liters) of an approved cleaning solution (example: Kay-5). USE WARM WATER AND FOLLOW THE MANUFACTURER’S SPECIFICATIONS.

Step 2
Pour the two gallons (7.6 liters) of cleaning solution into the hopper and allow it to flow into the freezing cylinder.

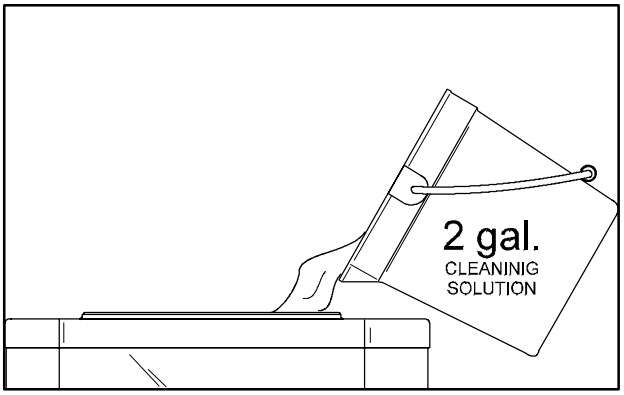


Figure 25

Step 3
While the solution is flowing into the freezing cylinder, brush clean the mix hopper, mix inlet hole, and mix level sensing probe.

Step 4
Remove the prime plug and allow all of the solution to flow into the freezing cylinder. Replace the prime plug.

Step 5
Place the control switch in the “WASH” position. This will cause the cleaning solution in the freezing cylinder to agitate.

Step 6
Place the control switch in the “OFF” position. Place an empty mix pail beneath the door spout. Open the draw valve and draw off all of the cleaning solution. When the solution stops flowing from the door spout, close the draw valve.

Disassembly

Step 1
BE SURE THE CONTROL SWITCH IS IN THE “OFF” POSITION.

Step 2
Remove the handscrews, freezer door, beater assembly, scraper blade, baffle blade, and the drive shaft from the freezing cylinder. Take these parts to the sink for cleaning.

Step 3
Remove the front drip tray and the splash shield and take them to the sink for cleaning.

Brush Cleaning

Step 1
Prepare a sink with an approved cleaning solution. USE WARM WATER AND FOLLOW THE MANUFACTURER’S SPECIFICATIONS. (**IMPORTANT:** Follow the label directions, as too STRONG of a solution can cause parts damage, while too MILD of a solution will not provide adequate cleaning.) Make sure all brushes provided with the freezer are available for brush cleaning.

Step 2
Remove the:

- seal from the drive shaft
- prime plug from the freezer door
- o-ring and front bearing from the freezer door
- door spout from the freezer door
- draw valve from the door spout.

Remove all o-rings and seals.

Note: To remove o-rings, use a single service towel to grasp the o-ring. Apply pressure in an upward direction until the o-ring pops out of its groove. With the other hand, push the top of the o-ring forward and it will roll out of the groove and can easily be removed. If there is more than one o-ring to be removed, always remove the rear o-ring first. This will allow the o-ring to slide over the forward rings without falling into the open grooves.

Step 3
Thoroughly brush clean all disassembled parts in the cleaning solution. Make sure all lubricant and mix film is removed. Place all the cleaned parts on a clean, dry surface to air dry.

Step 4
Return to the freezer with a small amount of cleaning solution. Brush clean the rear shell bearing at the back of the freezing cylinder. Use the black bristle brush.

Step 5
Wipe clean all exterior surfaces of the freezer.

Section 7 Important: Operator Checklist

During Cleaning and Sanitizing

ALWAYS FOLLOW LOCAL HEALTH CODES.

Cleaning and sanitizing schedules are governed by your State or local regulatory agencies and must be followed accordingly. The following check points should be stressed during the cleaning and sanitizing operations.
WE RECOMMEND DAILY CLEANING AND SANITIZING.

Troubleshooting Bacterial Count

☐ 1. Thoroughly clean and sanitize the machine regularly. This includes complete disassembly and brush cleaning of the required components.

☐ 2. Use all of the supplied brushes for thorough cleaning. The brushes are specially designed to reach all mix passageways.

☐ 3. Use the white bristle brush to clean the mix inlet hole which extends from the mix hopper down to the rear of the freezing cylinder.

☐ 4. Use the black bristle brush to thoroughly clean the rear shell bearing located at the rear of the freezing cylinder. Be sure there is a generous amount of cleaning solution on the brush.

☐ 5. Using a screwdriver and cloth towel, keep the female drive socket and rear shell bearing free of lubricant and mix deposits.

☐ 6. Properly prepare the cleaning and sanitizing solutions. Read and follow the label directions carefully. Too strong of a solution may damage the parts and too weak of a solution will not do an adequate job of cleaning or sanitizing.

☐ 7. If LOCAL HEALTH CODES PERMIT THE USE OF RERUN, make sure the rerun is stored in a sanitized covered stainless steel container and used the following day. Discard all rerun once a week.

Regular Maintenance Checks

☐ 1. Replace blades that are nicked, damaged, or worn.

☐ 2. Dispose of o-rings and seals if they are worn, torn, or fit too loosely. Replace faulty rubber parts with new ones.

☐ 3. Check the rear shell bearing for signs of wear (excessive mix leakage from the rear shell bearing into the front drip tray).

☐ 4. Follow all lubricating procedures as outlined in “Assembly”.

☐ 5. On air cooled units, check the condenser for an accumulation of dirt and lint. Dirty condensers will reduce the efficiency and capacity of the machine. Condensers should be cleaned **monthly.** Remove the right side and rear panels to gain access to the condenser. Use a soft brush to clean between the fins. **Never** use screwdrivers or other metal probes to clean between the fins.
Note: For machines equipped with an air filter, it will be necessary to vacuum clean the filters on a monthly schedule.

☐ 6. On water cooled units, check the water lines for kinks or leaks. Kinks can occur when the machine is moved back and forth for cleaning or maintenance purposes. Deteriorated or cracked water lines should be replaced only by an authorized Taylor mechanic.

Winter Storage

If the place of business is to be closed during the winter months, it is important to protect the freezer by following certain precautions, particularly if the building is subject to freezing conditions.

Disconnect the freezer from the main power source to prevent possible electrical damage.

On water cooled freezers, disconnect the water supply. Use air pressure to blow out any water remaining in the condenser, and then add a liberal amount of permanent type auto anti-freeze. **This is extremely important.** Failure to follow this procedure may cause severe and costly damage to the refrigeration system.

Your local Taylor Distributor can perform this service for you.

Wrap detachable parts of the freezer such as the beater assembly and the freezer door. Place these parts in a protected, dry place. Rubber trim parts and gaskets can be protected by wrapping them with moisture-proof paper. All parts should be thoroughly cleaned of dried mix or lubrication which attract mice and other vermin.

Section 8 Troubleshooting Guide

PROBLEM	PROBABLE CAUSE	REMEDY	PAGE REF.
1. The product is too stiff.	a. The product is not properly mixed.	a. Carefully follow directions for mixing product.	- - -
	b. There is a mix low condition.	b. Add mix to the mix hopper.	6
	c. The torque control needs adjustment.	c. Adjust the control accordingly.	6
	d. The mix inlet hole is clogged.	d. Clean the mix inlet hole.	10
2. The product is not thick enough.	a. The product is not properly mixed.	a. Carefully follow directions for mixing product.	- - -
	b. The torque control needs adjustment.	b. Adjust accordingly.	6
	c. The beater rotation is incorrect.	c. Contact a service technician.	- - -
	d. Water supply restricted.	d. Make sure the water is on and that there are no leaks or kinks in the water lines.	14
	e. The condensers are dirty.	e. Clean the condensers monthly.	14
3. No product is being dispensed.	a. The product is not properly mixed.	a. Carefully follow directions for mixing product.	- - -
	b. The product is frozen in the freezing cylinder.	b. Adjust the torque control accordingly.	6
	c. The beater assembly is not rotating at all, or is rotating clockwise. The control switch is not placed in the “AUTO” position.	c. Control switch must be in “AUTO”. If beater is rotating clockwise, call service technician to correct rotation to counterclockwise.	11
	d. The mix inlet hole is clogged.	d. Clean the mix inlet hole.	10
4. The freezer will not operate with the control switch in “AUTO” or “WASH” mode.	a. The unit is unplugged.	a. Check the plug at the wall receptacle.	- - -
	b. The beater motor is experiencing an overload condition.	b. Place the control switch in the “OFF” position. Allow the motor to cool. Place the control switch in the “AUTO” position. Call a service technician if the beater motor experiences another overload condition.	- - -
	c. The fuse is blown, or the circuit breaker is off.	c. Replace the fuse or turn the breaker on.	- - -

PROBLEM	PROBABLE CAUSE	REMEDY	PAGE REF.
5. There is no compressor operation with the freezer in the “AUTO” mode.	a. The beater motor is experiencing an overload condition.	a. Place the control switch in the “OFF” position. Allow the motor to cool. Place the control switch in the “AUTO” position. Call the service technician if the beater motor experiences another overload.	- - -
	b. The condenser is dirty (A/C).	b. Clean the condenser monthly.	14
	c. The water supply is off (W/C).	c. Turn the water on.	- - -
6. There is leakage from the rear shell bearing into the front drip tray.	a. There is improper or inadequate lubrication on the drive shaft seal.	a. Use an approved food grade lubricant (example: Taylor Lube) and follow lubrication procedures.	7
	b. The seal on the drive shaft is worn, missing, or incorrectly installed.	b. Replace or correctly install rubber parts on the drive shaft.	8
	c. The rear shell bearing is worn.	c. Contact a service technician to replace the rear shell bearing.	- - -
7. There is excessive mix leakage from the door spout.	a. Inadequate lubrication of draw valve o-rings.	a. Lubricate the parts properly.	8
	b. Wrong type of lubricant on draw valve o-rings.	b. Use food grade lubricant (example: Taylor Lube).	7
	c. Worn or missing draw valve o-rings.	c. Replace or install the o-rings on the draw valve.	8
	d. Worn or missing draw valve seal.	d. Replace or install the draw valve seal.	8
	e. Door spout not secure.	e. Tighten the thumb screws.	8
8. There is frozen mix in the feed tube.	a. The product is not properly mixed.	a. Carefully follow directions for mixing product.	- - -
	b. The mix level is too low, or the unit was in the “AUTO” mode with the “MIX LOW” light flashing for more than 15 minutes.	b. Add mix. Do not leave the unit in the “AUTO” mode with the “MIX LOW” light flashing.	6
	c. The mix inlet hole is clogged.	c. Clean the mix inlet hole.	10

Section 9 Parts Replacement Schedule

PART DESCRIPTION	PART NUMBER	EVERY 3 MONTHS	EVERY 6 MONTHS	ANNUALLY
Scraper Blade	046840	Inspect & Replace if Necessary	Minimum	
Beater Baffle	046839	Inspect & Replace if Necessary	Minimum	
Drive Shaft Seal	032560	X		
Freezer Door O-Ring	027814	X		
Door Port O-Ring	046830	X		
Front Bearing	046834	X		
Draw Valve O-Ring	047356	X		
Prime Plug O-Ring	029751	X		
White Bristle Brush, 1” x 2”	013073		Inspect & Replace if Necessary	Minimum
White Bristle Brush, 3” x 7”	023316		Inspect & Replace if Necessary	Minimum
Black Bristle Brush, 1” x 2”	013071		Inspect & Replace if Necessary	Minimum
Double Ended Brush	013072		Inspect & Replace if Necessary	Minimum

Refer to Parts List on page18 when ordering above parts.

* See Taylor Warranty Card
\+ Available Separately

J3064847/Up

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
ACCUMULATOR-COPPER 2DIA 10LG	047062	1	1	B	AIR COOLED UNITS ONLY	
BEARING-FRONT *380/1*	046834	1	1	C		
BEARING-REAR SHELL *380*	045401	1	1	C		
+GUIDE-DRIP SEAL	028992	1	1	C		
+NUT-BRASS BEARING	028991	1	1	C		
+WASHER-BEARING LOCK	012864	1	1	C		
BEARING-UNIT REAR	025629	1	1	B		
BEATER A.- *380/1*	X50525	1	1	B		
+BAFFLE-BEATER *380/1*	046839	1	1	C		
+BLADE-SCRAPER *380/1*	046840	1	1	C		
BELT-POLY V-490J10	033142	1	1	C		
BRACKET-DRIP TRAY *380/*L	046847	1	1	B		
+SCREW-1/4-20X1/2 HEX CAP	005192	2	2	C		
BRACKET-DRIP TRAY *380/1*R	046846	1	1	B		
+SCREW-1/4-20X1/2 HEX CAP	005192	2	2	C		
BRUSH-DOUBLE ENDED-PUMP & FEED TUBE	013072	1	1	C		
BRUSH-DRAW VALVE 1ODX2X17L	013073	1	1	C		
BRUSH-MIX PUMP BODY-3X7WHITE	023316	1	1	C		
BRUSH-REAR BRG 1IN.DX2IN.LGX14	013071	1	1	C		
COMPRESSOR AK9474J	045431-	1		*		
+CAPACITOR-RUN- 25 UF/370V	033045	1		B	115 VOLT	
+CAPACITOR-RUN- 15 UF/370V	027087	1		B	208/230 VOLT	
+CAPACITOR-START- 72-88UF/330V	039567	1		B	115 VOLT	

* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
+CAPACITOR-START- 72-88UF/330V	039557-27	1		B	208/230 VOLT	
+GROMMET-COMPRESSOR MOUNT	039919	4		C		
+RELAY-START-COMPRESSOR	045432-12	1		B	115 VOLT	
+RELAY-START-COMPRESSOR	049127	1		B	208/230 VOLT	
+SLEEVE-MOUNTING-COMP-AE	039920	4		C		
COMPRESSOR M51B143BBCA	036880-		1	*		
+CAPACITOR-RUN- 25 UF/440V	037431		1	B		
+CAPACITOR-START- 161-193UF/250V	031790		1	B		
+GROMMET-COMPRESSOR MOUNT	037428		4	C		
+RELAY-START-COMPRESSOR	037430		1	B		
+SLEEVE-MOUNTING-COMP	037429		4	C		
CONDENSER-AC-12LX14HX1.87T 3RW	028021	1		B	AIR COOLED	
CONDENSER-WC	018278	1	1	B	WATER COOLED	
CONTROL-MIX LEVEL	031799-	1	1	B		
CORD-POWER-125V-NEMA 5-20P-8'L	045666	1	1	B	115 VOLT	
CORD-POWER-250V-NEMA 5-20P-8'L	046088	1	1	B	208/230 VOLT	
COVER-HOPPER-12 QT	045416	1	1	B		
DECAL-CLEAN INST.-HOPPER	019029	1	1	C		
DECAL-MAG-FROZEN DRINKS	046974	1	1	C	STANDARD UNIT	
DECAL-MAG-FAT TUESDAYS	048062	1	1	C	FAT TUESDAYS	82
DECAL-PANEL-380*RD30*	045967	1	1	C		
DECAL-POWER SWITCH	046089	1	1	C		
DECAL-TROUBLESHOOTING	038374	1	1	C		
DECAL-WARNING *PANEL*	036529	3	3	C		
DIAGRAM-WIRING *380/1*	046962-	1	1	C		

* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
DOOR A.-PARTIAL *380/381*	X47648	1	1	B		
+Additional parts - see Kit A.-Draw Valve						
+O-RING-8-3/8 ODX.105W	027814	1	1	C	DOOR GASKET	
+PLUG-PRIME *380/1*	046833	1	1	C		
+O-RING-9/32 OD X 1/16 WALL	029751	1	1	C		
+SCREW-1/4-20X9/16 THUMB-300 SS	047632	2	2	C	HOLD SPOUT TO DOOR	
DRYER-FILTER 1/4 X 1/4 SOLDER	045643	1		C		
DRYER-FILTER 3/8 X 1/4 SOLDER	045866		1	C		
FASTENER-CLIP 10-24 J TYPE	046722	8	8	C	PANEL FASTNERS	
FITTING-DRAIN EYELET-1/2OD FLG	046721	1	1	B	BASE PAN DRAIN FITTING	
HOSE-RUBBER	050200		5.5 ft	C		
KIT A.-DRAW VALVE-PULL STYLE	X47352	1	1		J4072652/UP	83
KNOB-DRAW VALVE-BLACK PLASTIC	047358	1	1	B		
O-RING-2.375 OD X 1/16W	046830	1	1	C	DOOR PORT	
PLATE-DRAW SPOUT MOUNTING	047355	1	1	B		
SPOUT-DOOR *380/*ZERO WASTE	047354	1	1	B		
SPRING-COMP.845X.055X3.5-SS	047357	1	1	B		
VALVE-DRAW *380/1*ZERO WASTE	047353	1	1	B		
+O-RING-.943 OD X .737 ID	047356	3	3	C		
ROTATIONAL STYLE DOOR COMPONENTS					J4072652/PRIOR	83
HANDLE A.-DRAW SHAFT	X45860	1	1	B		
O-RING	046829	2	2	C	DRAW VALVE	
O-RING-2.375 OD X 1/16W	046830	1	1	C	DOOR PORT	
SEAL - DRAW VALVE	046828	1	1	C	DRAW VALVE	
SPOUT-DOOR	046826	1	1	B		

* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
VALVE-DRAW	046827	1	1	C		
KIT A.-TUNE UP *380/1*	X47513	1	1	C	J4072652/UP PULL STYLE DOOR	
BEARING-FRONT *380/1*	046834	1	1	C		
O-RING-.943 OD X .737 ID	047356	1	1	C		
O-RING-2.375 OD X 1/16W	046830	1	1	C		
O-RING-8-3/8 ODX.105W	027814	1	1	C		
O-RING-9/32 OD X 1/16 WALL	029751	1	1	C		
SEAL-DRIVE SHAFT	032560	1	1	C		
KIT A.-TUNE UP*380/1*	X46855	1	1	C	J4072652/PRIOR ROTATIONAL STYLE DOOR	
BEARING-FRONT *380/1*	046834	1	1	C		
O-RING-2.00 OD X 1/16W	046829	2	2	C		
O-RING-2.375 OD X 1/16W	046830	1	1	C		
O-RING-8-3/8 ODX.105W	027814	1	1	C		
O-RING-9/32 OD X 1/16 WALL	029751	1	1	C		
SEAL-DRIVE SHAFT	032560	1	1	C		
LABEL-DOOR CAUTION	032749	1	1	C		
LABEL-MOVING PARTS WARNING	024315	3	3	C		
LABEL-THICKER-ARROW LEFT	046267	1	1	C		
LEG-4-3/8-16 STUD-PLASTIC	024755	4	4	B	J4020000/UP	79
+CAP-RUBBER	037268	4	4	C		
LEG-4-3/8-16 STUD	036397	4	4	B	J4020000/PRIOR	79
LEVER-TORQUE ADJUST *380/1*	050079	1	1	B	J6030000/UP	104
+E-RING 1/4	032190	2	2	C		
+PLATE-TORQUE ADJUSTMENT *380/1	046823	1	1	B		

* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
+SHIELD-TORQUE SWITCH *380/1*	047606	1	1	B		
LIGHT-INDICATOR-RED LENS	075560-	1	1	B		
LUBRICANT-TAYLOR 4 OZ.	047518	1	1	C		
MAGNET	075559	1	1	B	J6030000/UP	104
MAN-OPER 380/381	047455-M	1	1	C		
MOTOR-FAN-25W	015184-	1		B	AIR COOLED	
+BRACKET-FAN	015186	1		B	AIR COOLED	
+FAN-5 BLADE 11 PUSH 24DEG CW	035966	1		B	AIR COOLED	
MOTOR-1/3 HP-OSCILLATION MOUNT	047066-	1	1	*		
BRACKET-BTR MTR-SNUBBER 380/81	047158	1	1	B		
BRACKET-TORQUE SWITCH *380/1*	050068	1	1	B	J6030000/UP	104
BUMPER-MOTOR STOP	048058	2	2	B		
PLATE-DRAW SWITCH *452 HT*	043527	2	2	B		
SNUBBER-BTR MTR *380/381*	047159	1	1	B		
SWITCH-REED	050067	2	2	B	J6030000/UP	104
NUT-STUD *380*RD30*	045644	4	4	B	(HANDSCREWS)	
PAN-DRIP *380/1*	046852	1	1	B		
PANEL-FRONT *380/1*	046845	1	1	B		
PANEL-REAR *380/1*	046813	1	1	B		
PANEL-SIDE *380/1*LEFT	046844	1	1	B		
PANEL-SIDE RIGHT A/C	047537	1		B	AIR COOLED	
PANEL-SIDE RIGHT W/C	046843	1	1	B	WATER COOLED	
PROBE A.-MIX *SQUARE*	X30922	1	1	B		
+DISC-PROBE *SQ HOLE*	030965	1	1	B		
+SPACER-PROBE *SQ HOLE*	030966	1	1	B		

* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
PULLEY-10J- 1.125PD-1/2BORE	046726	1	1	B	BEATER MOTOR	
PULLEY-10J-11PD-5/8BORE	025570	1	1	B	GEAR	
RELAY-3 POLE-24 AMP-120 VAC	039538-12	1	1	B	MAIN COMP/BEATER MOTOR	
RELAY-3 POLE-20A-208/240	012725-33	1	1	B	MAIN COMP/BEATER MOTOR	
RELAY-DPDT-20 A-120V	050183-12	2		B	DELAY TIMER 115 VOLT	104
RELAY-DPDT-20 A-230V	026581-27	2	2	B	DELAY TIMER 230 VOLT	
RETAINER-SPRING	050180	1	1	B	J6030000/UP	104
SANITIZER KAY-5 125 PACKETS	041082	1	1	C		
SHAFT A.-DRIVE *380/1*	X50521	1	1	B		
+SEAL-DRIVE SHAFT	032560	1	1	C		
SHELL A.-INSULATED *380/1*	X46803	1	1	*		
+STUD-FREEZER DOOR *103-232*	023057	4	4	B		
SHIELD-SPLASH *380/1*	046851	1	1	B		
SHROUD-FAN *142*	039663	1		B		
SPRING-EXTENSION .188 X .018 X 1.75	050065	2	2	B	J6030000/UP	104
SPRING-EXTENSION .50 X .041 X 1.75	050066	1	1	B	J6030000/UP	104
SWITCH-PRESSURE 440 PSI-SOLDER	046362	1		B	AIR COOLED	
SWITCH-PRESSURE 350 PSI-SOLDER	046431	1	1	B	WATER COOLED	
+BOOT-PRESSURE SWITCH	034682	1	1	C		
SWITCH-TOGGLE-DPDT*ON-OFF-ON	014464	1	1	B		
+BOOT-TOGGLE SWITCH	043398	1	1	C		
TIMER-DELAY ON MAKE 2 SEC.	030667-	1	1	B		
TRAY A.-DRIP *380*	X46848	1	1	B		
TUBE-CAPILLARY .021ID X 9 FT	020059	1	1	B		
TUBE-VINYL 3/8 ID X 9/16 OD	020943-25	1	1		BULK UNDER P/N R30315	

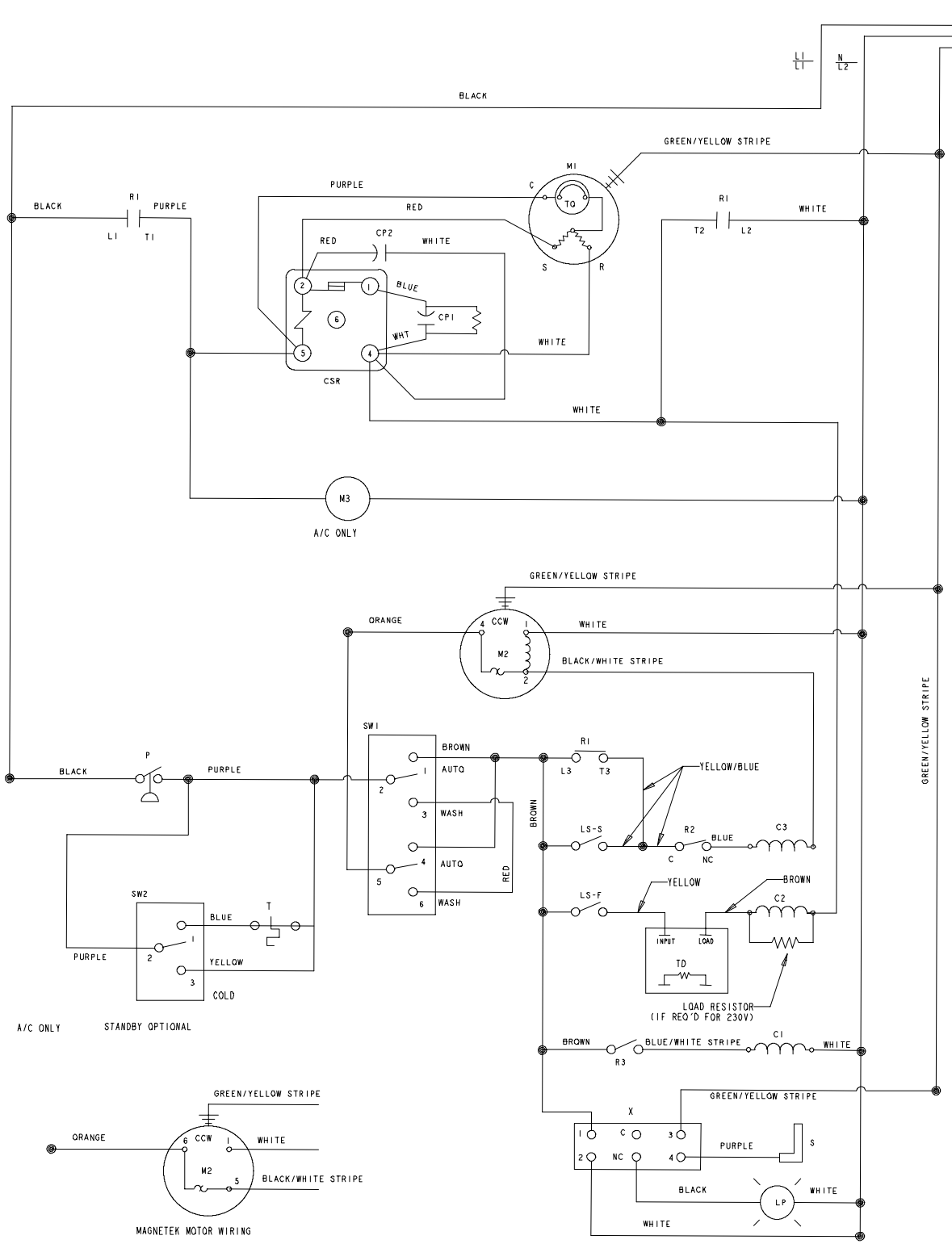
* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
VALVE-ACCESS 1/4FL X 1/4SOLDER	044404	1	1	B		
VALVE-ACCESS 1/4FL X 3/8SDR-90	044455	1		B		
VALVE-EPR 1/4S	022665	1	1	B		
VALVE-EXP-THERMO-1/4MF X 1/4FP	018217-1	1	1	B		
+BOOT-EXPANSION VALVE	027137	1	1	C		
VALVE-WATER 3/8 REG/HEAD	046686		1	B	WATER COOLED	
50 Hz						
COMPRESSOR	039558-34	1		*	230-50-1	
COMPRESSOR	036880-34		1	*	230-50-1	
+CAPACITOR-RUN- 15UF/370V	034222	1	1	B	230-50-1	
+CAPACITOR-START-77-88UF/330V	039567	1	1	B	230-50-1	
+RELAY-START-COMPRESSOR	039913	1	1	B	230-50-1	
PULLEY-10J-1.375PD-1/2BO	047798	1	1	B	BEATER MOTOR	
RELAY-3 POLE-20A-208/240	012725-33	1	1	B	MAIN COMP/BEATER MOTOR	

* See Taylor Warranty Card
\+ Available Separately

DESCRIPTION	PART NUMBER	380 QTY.	381 QTY.	WARR. CLASS	REMARKS	PARTS UPDATE
Light Box						
KIT A.-LIGHT BOX-380	X47417-12	1		B		
KIT A.-LIGHT BOX-381	X47417-27		1	B		
BOX A.-LIGHT *380*	X47418-12	1		B		
BOX A.-LIGHT *381*	X47418-27		1	B		
BALLAST-F27BX FLUORESCENT	045442-12	1		B		
BALLAST-F27BX FLUORESCENT	045442-27		1	B		
BULB-LIGHT-FLUORESCENT U	045445	1	1	C		
CLIP-FLUORESCENT LAMP	045444	2	2	B		
DECAL-DEC-380 FROZEN DRINKS	045764-7	1	1	C		
LENS-LIGHT BOX *380/1*	047429	1	1	C		
SOCKET-FLUORESCENT LAMP	045443	1	1	B		
SWITCH-TOGGLE-SPST	012626	1	1	B		
BUSHING-SNAP 11/16IDX7/8OD	010548	1	1	C		
GASKET-LIGHT BOX	045737	1	1	C		
INSTRUCTION-LIGHT BOX *381*	047417-DRW	1	1	C		
NUT-10-32 MF LOCK	020983	2	2	C		
SCREW-10-32X3/8 TRUSS HD-SS	024298	2	2	C		
TEMPLATE-STANDY *380/1*	047426	1	1	C		

Models 380/381
046962-12, 27 & 34

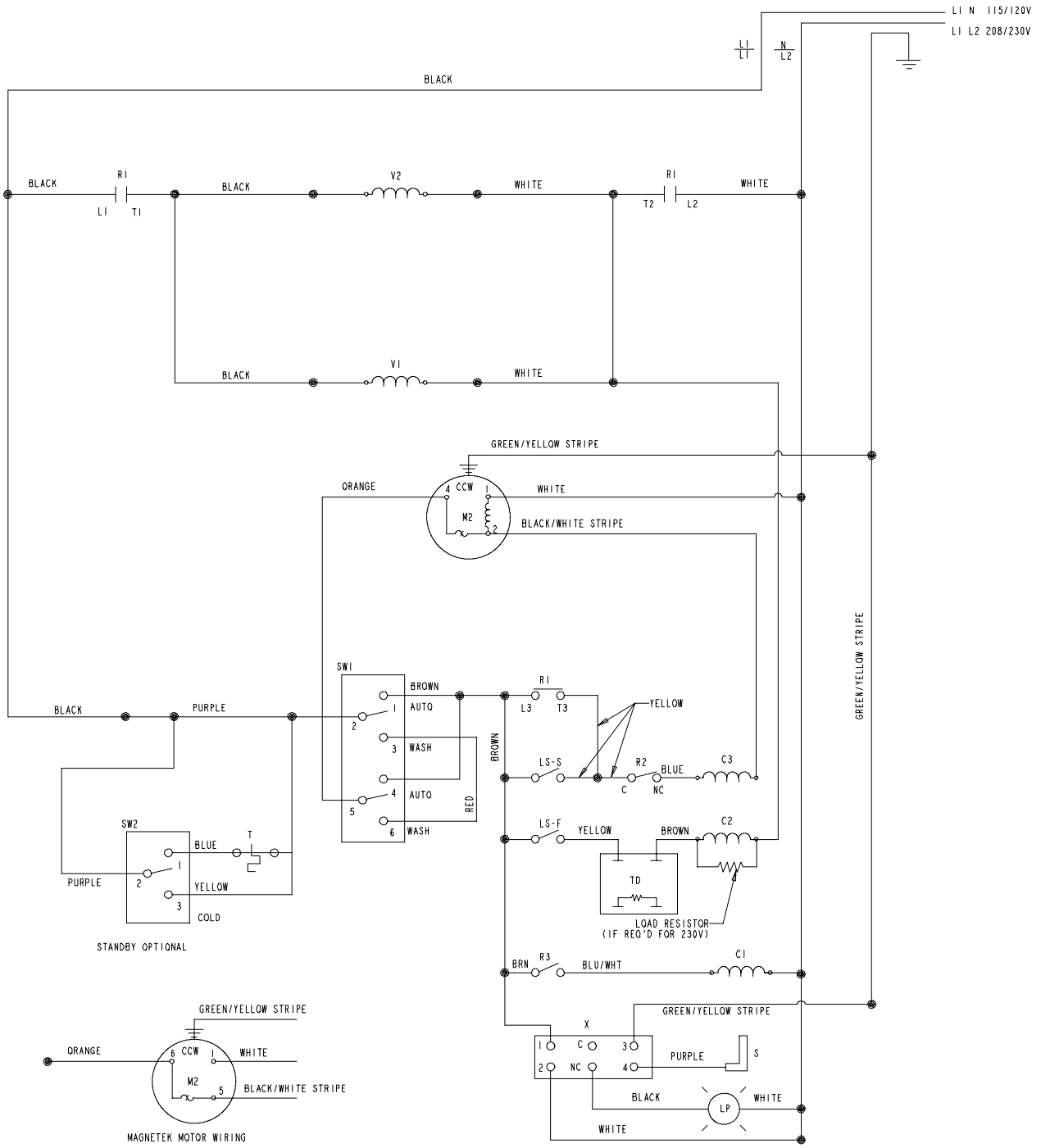


SYMBOL	LEGEND
CSR	COMPRESSOR START RELAY
C1	COIL-COMPRESSOR RELAY (R1)
C2	COIL-VISCOSITY RELAY-FIRM
C3	COIL-VISCOSITY RELAY-SOFT
CP1	START CAPACITOR - COMPRESSOR
CP2	RUN CAPACITOR - COMPRESSOR
FL	MARKED POSITION ON TERMINAL STRIP
L1, L2	POWER SUPPLY-1 PHASE
LP	MIX LOW INDICATOR LAMP
LS-S	LIMIT SWITCH-SOFT
LS-F	LIMIT SWITCH-FIRM
M1	COMPRESSOR MOTOR
M2	BEATER MOTOR
M3	FAN MOTOR-A/C ONLY
P	HI PRESSURE LIMIT SWITCH
PC	POWER SUPPLY CORD
R1	RELAY, COMPRESSOR - 4 POLE
R2	RELAY-VISCOSITY-SOFT
R3	RELAY-VISCOSITY-FIRM
S	SENSOR, MIX LEVEL
SW1	SWITCH, 3 POSITION (CENTER-OFF) TOGGLE
SW2	SWITCH, 3 POSITION (CENTER-OFF) TOGGLE
T	SWITCH, 3 POSITION (CENTER-OFF) ROCKER
TD	TIME DELAY, 2 SEC.
X	CONTROL MIX LEVEL
TO	THERMAL OVERLOAD (COMPRESSOR)
RESISTOR	LOAD RESITOR(230V ONLY, IF REQ'D

NOTES:

1) THIS DIAGRAM TO BE USED FOR -12,-27 &-34

Model 380
049020-12



SYMBOL	LEGEND
C1	COIL-SOLENOID RELAY (R1)
C2	COIL-VISCOSITY RELAY FIRM
C3	COIL-VISCOSITY RELAY SOFT
L1, L2	POWER SUPPLY-1 PHASE
LP	MIX LOW INDICATOR LAMP
LS-S	LIMIT SWITCH-SOFT
LS-F	LIMIT SWITCH-FIRM
M2	BEATER MOTOR
PC	POWER SUPPLY CORD
R1	RELAY, SOLENOID - 4 POLE
R2	RELAY-VISCOSITY
S	SENSOR, MIX LEVEL
SW1	SWITCH, 3 POSITION (CENTER-OFF) TOGGLE
SW2	SWITCH, 3 POSITION (CENTER-OFF) TOGGLE
T	SWITCH, 3 POSITION (CENTER-OFF) ROCKER
TD	TIME DELAY, 2 SEC.
X	CONTROL MIX LEVEL
V1	VALVE-SOLENOID-SUCTION
RESISTOR	LOAD RESITOR(230V ONLY, IF REQ'D
V2	VALVE-SOLINOID-LIQUID